

Work Order ID 76762

76762

Page 1

Monday, November 21, 2011 10:31:56 AM

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: Date: 11-11-21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2661	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00				8	φ		
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>E</u>								

110	CONVENTIONAL MILLING MACHINE	0.00				8	φ		
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

B.A 11/12/23

B.A 11/12/28

F.K 11/12/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat		0.00							
Powder Coating	Memo								
	START TIME: 2:00								
	FINISH TIME: 3200F								
	OVEN TEMPERATURE: 2:30								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging	Memo	0.00							
Packaging									

8X0 M-L 12/01/05

8 BL 12-1-5

C 12/01/06 (8)

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/99
MF
12-01-06

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Picklist Print

Monday, November 21, 2011 10:32:00 AM

Page 1

Work Order ID: 76762

76762

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	134.0000	1	8			
D6101-003									**			11/12/22	
Saddle Billet, 7075													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
74680	26	
→ 76837		8.0

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DART AEROSPACE LTD	Work Order: 74762
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.132	0.132	0.132	0.132		
B	0.100	0.140		0.126	0.126	0.126	0.126		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.255	0.255	0.255	0.255		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		0.227	0.227	0.227	0.227		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.922	0.922		
AA	0.490	0.510		0.497	0.495	0.496	0.496		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: M.A. / K.K.
Date: 11/12/23 / 11/12/29

Audited by: SL
Date: 12-01-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

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Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		0.132	0.132	0.132	0.132		
B	0.100	0.140		0.126	0.126	0.126	0.126		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.255	0.255	0.255	0.255		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		0.227	0.227	0.227	0.227		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
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U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.922	0.922		
AA	0.490	0.510		0.499	0.499	0.501	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

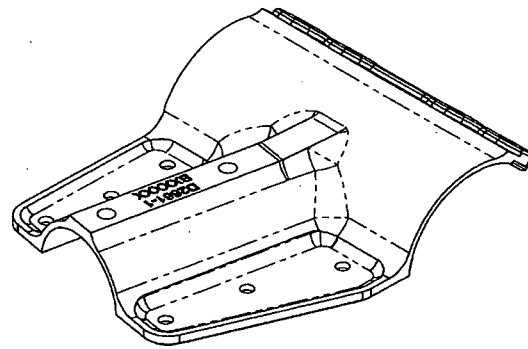
Measured by: H.A. / F.K.
Date: 11/12/23 / 11/12/29

Audited by: J
Date: 12-01-03

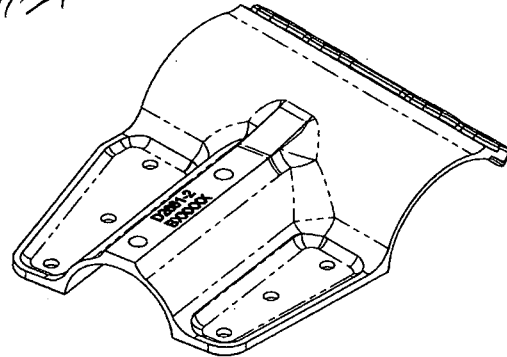
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	NA

SHOP COPY
 RETURNED
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 76762

R11-11-21



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>GP</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>GP</i>	D2661	SHEET 1 OF 5
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

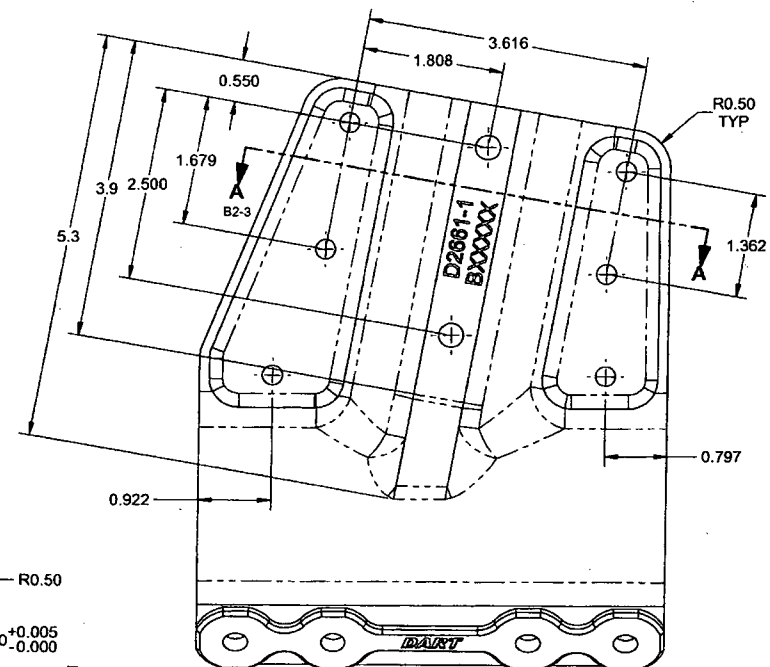
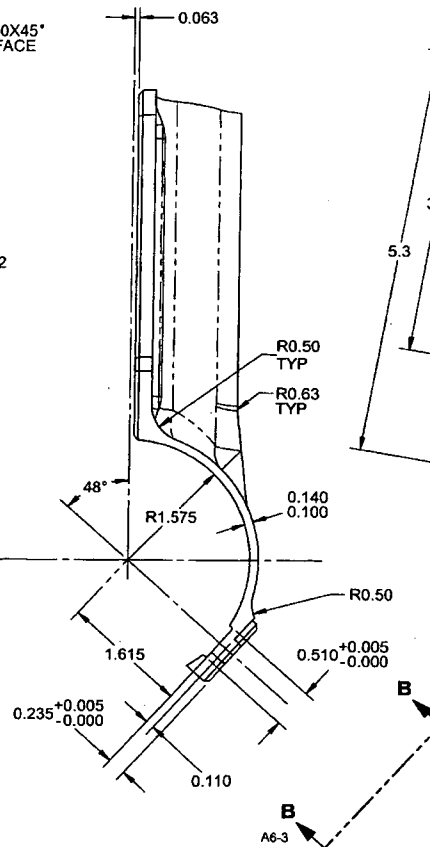
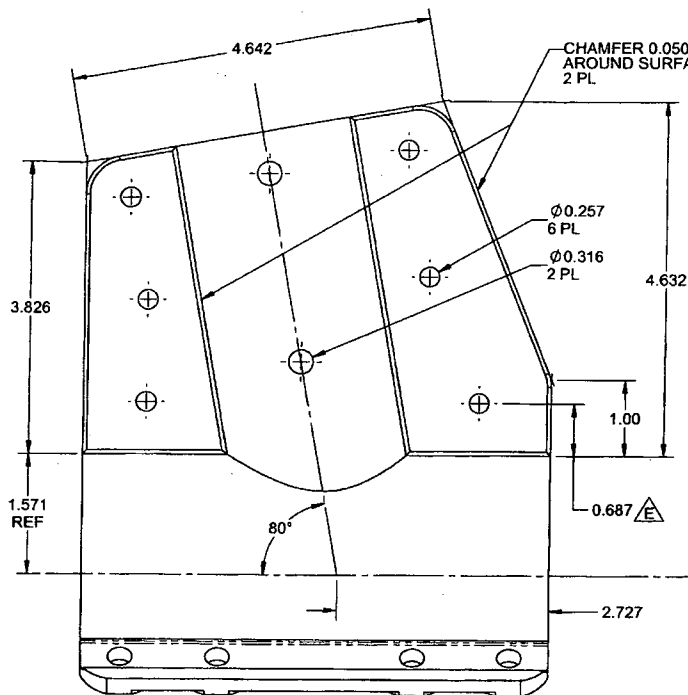
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NOTE: Date & initial all entries



D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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RELEASED
2011-11-16

76742

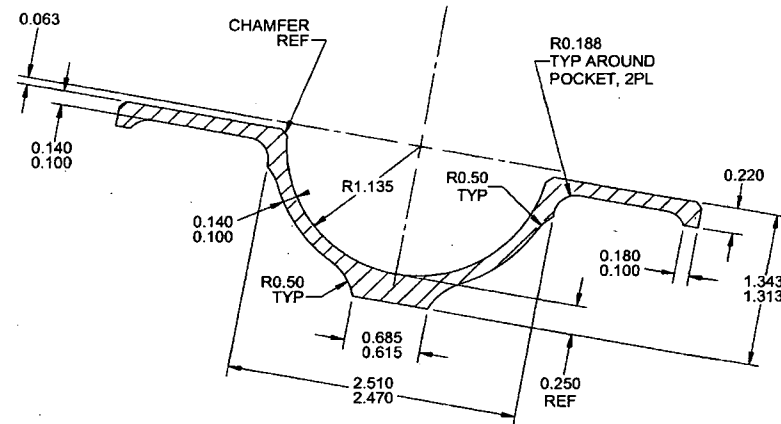
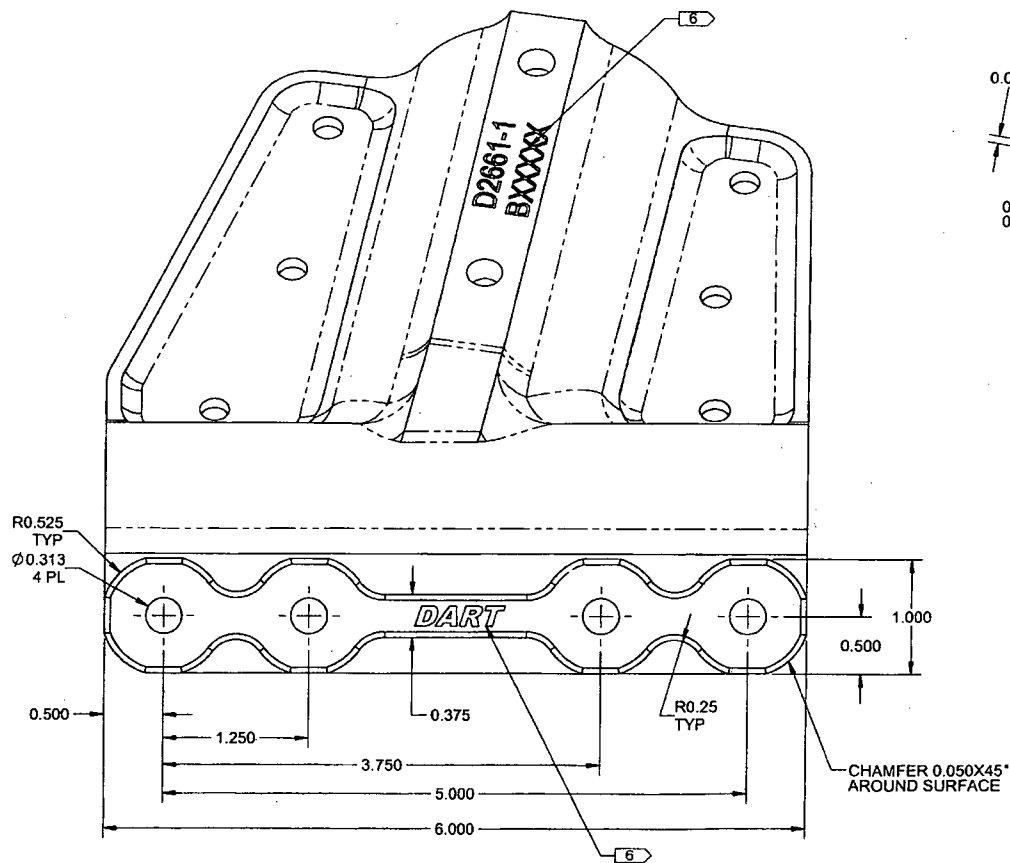
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R 2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

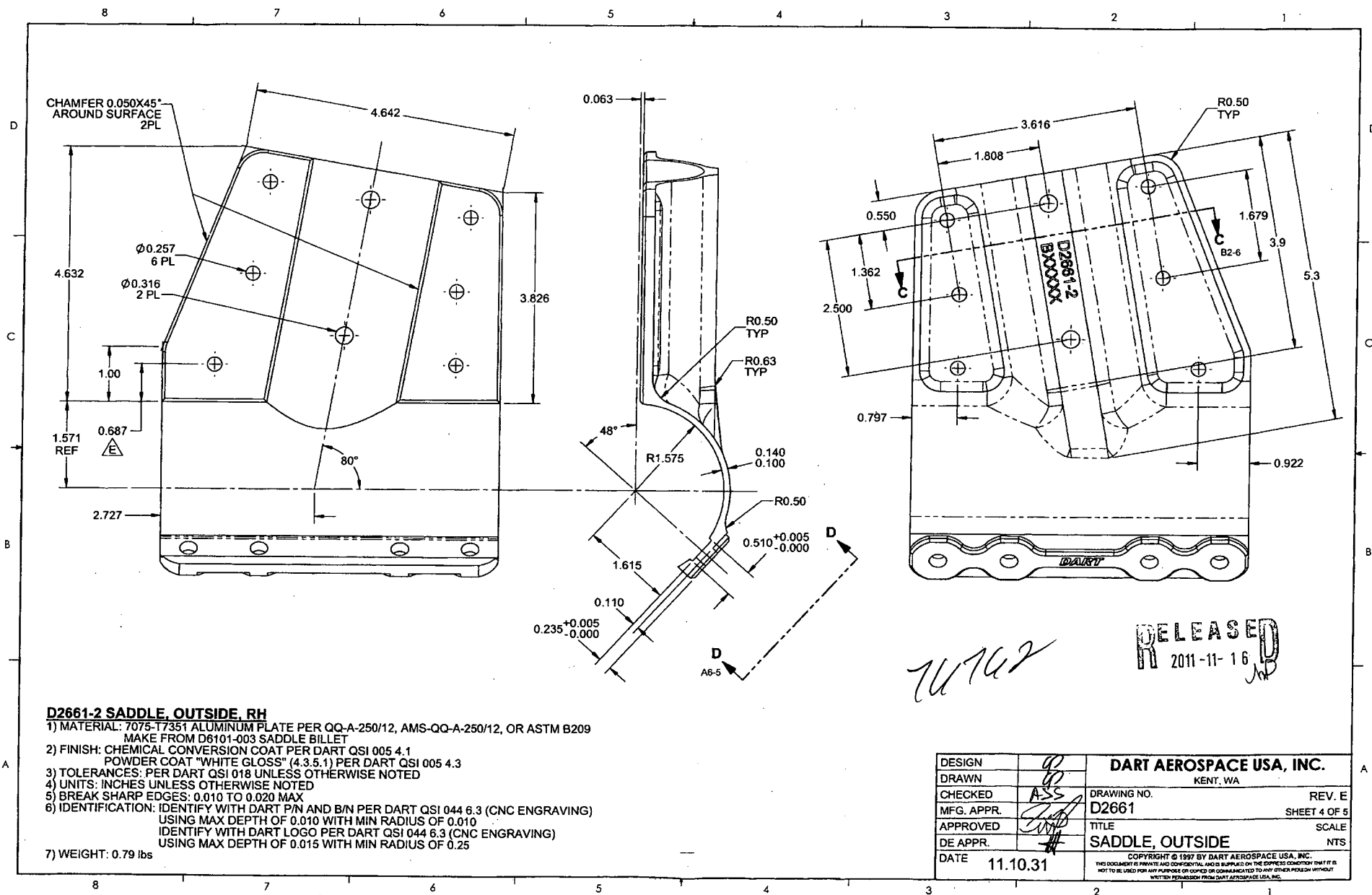
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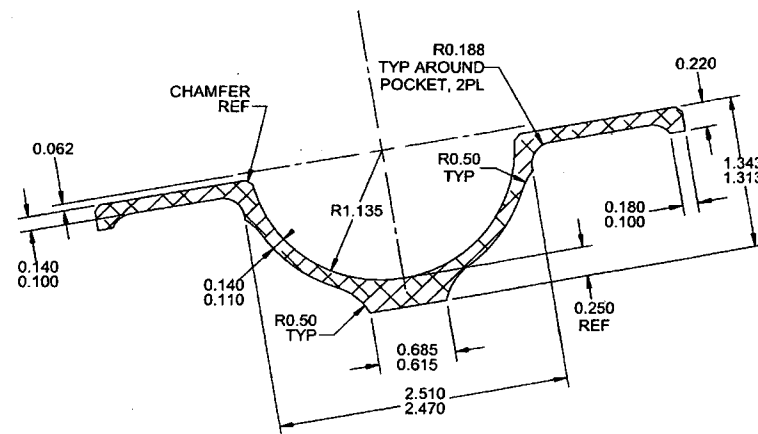
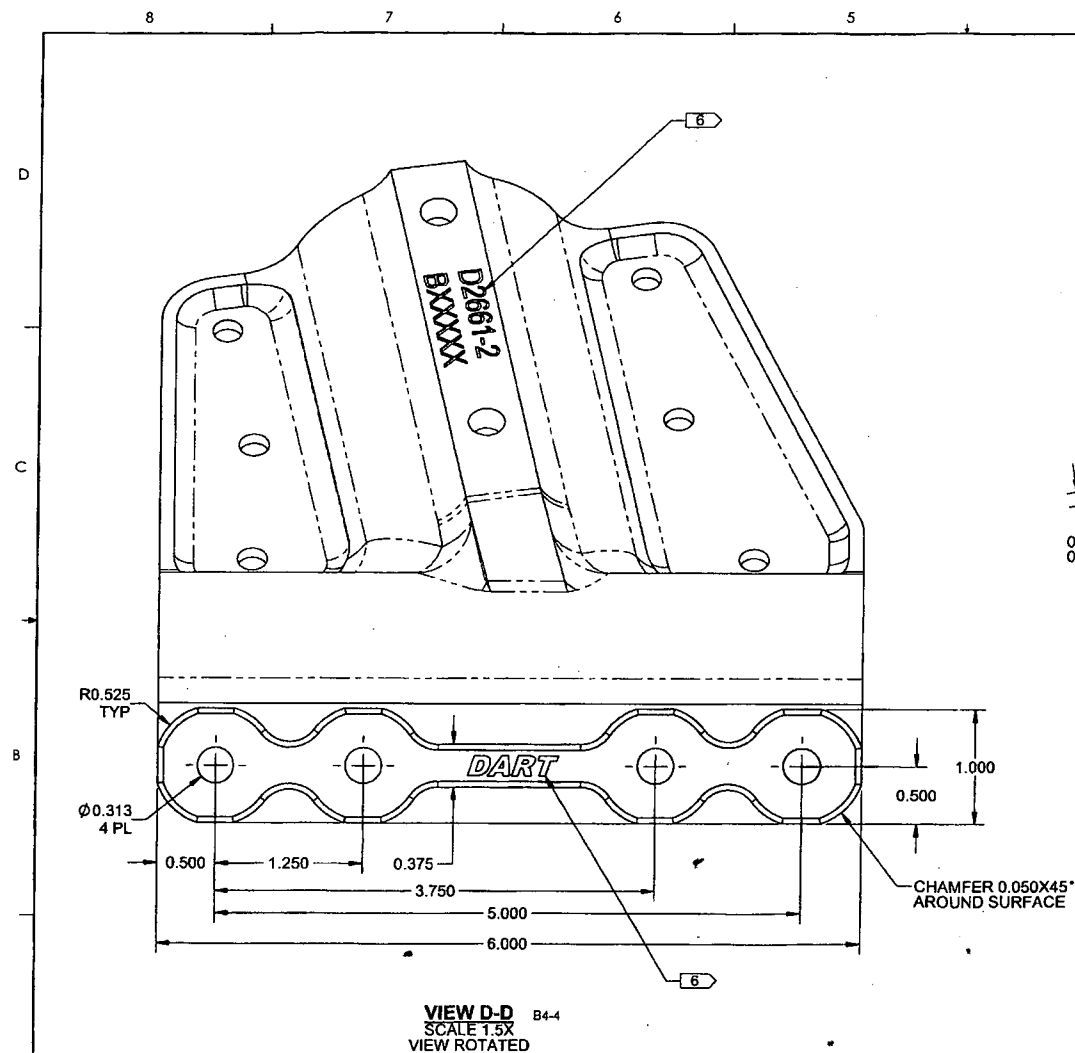
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SECTION C-C C1-4
SCALE 1.5X

74742

RELEASED
2011-11-16

DESIGN	g	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries